

Work Order ID 64560

Wednesday, December 08, 2010 10:25:45 A



Page 1

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 12/8/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: *10/2-8*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev D								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Inspect part number and batch number are programmed correctly. ☐ Fixturing Inspection last completed 64560 by SL ☐ Machine Step No 1 of Folio and inspect per attached Dimension Sheet ☐ Machine Step No 2 of Folio

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/09/19

8

2

Photo

B.A 11/09/21

8

0

B.A 11/09/20

8

0

W/O: 64560		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2662-1 PAR #: N/A Fault Category: Mechanics / Program NCR: Yes No DQA: 11 Date: 11/10/03
 11-858 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/10/04

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/19	110	2 parts scrapped. → wall thickness on first one is .178 on small bore → wall thickness on the other doesn't follow the rap on drawing R.C program development	<u>11/09/19</u> <u>OSI/02</u>	SCRAP + REPLACE B/N: <u>72225</u>	<u>B.A</u> <u>11/09/19</u>	<u>22</u> <u>11/09/19</u>	<u>11/09/19</u>	<u>S</u> <u>11/09/19</u>
		LOFT.						

NOTE: Date & initial all entries

Work Order ID 64560

Wednesday, December 08, 2010 10:25:45 A



Page 2

Item ID: D2662-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle, LH In 206					
Start Date: 12/8/2010	Start Qty: 8.00		Cust Item ID:		
Required Date: 12/22/2010	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00				8	2		
QC Quality Control	Memo	0.00	Re	11. 7. 25					
140 	Chemical Conversion Coat per QSI005 4.1	0.00				8	11-9-26		
HandFinish Hand Finishing	Memo	0.00							
150 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo	0.00							

START TIME: 2:45
FINISH TIME: 3:15
OVEN TEMPERATURE:

W118439

3200F

3:15

8x4 M/L 11/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64560

Page 3

Wednesday, December 08, 2010 10:25:45 A

Item ID: D2662-1

Accept



Setup Start



Revision IP:

Stop



Item Name: Saddle, LH In 206

Start Date: 12/8/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 BL 11-9-28

170

Identify as per dwg & Stock Location: ST 135 0.00



Packaging

Memo

0.00

Packaging

GP SP 11-09-28

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/9/28

ME 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, December 08, 2010 10:25:49 AM

Page 1

Work Order ID: 64560

Parent Item: D2662-1

Parent Item Name: Saddle, LH In 206



Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.06.22 Removed P/O for powder coat EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	8.0000	1	8			

Saddle Billet

Location	Loc Qty	Loc Code
MAT40	8	
61385	2	
63537	6	

72225

8.0
+2.0

B.A 11/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 64540
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.115	0.115	0.114	0.113	Mic	GA-03
B	0.100	0.140		0.119	0.114	0.118	0.114	Mic	11B-120
C	1.125	1.145		1.1377	1.134	1.1348	1.133	Dial	HAASZ
D	0.615	0.685		0.683	0.683	0.683	0.683	Vern	GA-01
E	0.240	0.260		0.247	0.250	0.250	0.247	"	"
F	1.313	1.343		1.327	1.322	1.321	1.322	H-6	31006
G	0.210	0.230		0.221	0.219	0.218	0.219	Vern	GA-01
H	0.100	0.180		0.135	0.135	0.135	0.135	"	"
I	2.470	2.510		2.490	2.490	2.490	2.490	"	"
J	1.565	1.585		1.5827	1.574	1.5748	1.5745	Dial	HAASZ
K	0.235	0.240		0.238	0.238	0.238	0.238	Vern	GA-01
L	0.100	0.120		0.110	0.110	0.110	0.110	"	"
M	0.990	1.010		0.992	0.992	0.992	0.992	"	"
N	0.510	0.515		0.514	0.514	0.514	0.514	"	"
O	5.990	6.010		6.000	6.000	6.000	6.000	"	"
P	1.245	1.255		1.250	1.250	1.250	1.250	"	"
Q	2.495	2.505		2.500	2.500	2.500	2.500	"	"
R	0.313	0.318		0.315	0.315	0.315	0.315	"	"
S	0.315	0.322		0.317	0.317	0.317	0.317	"	"
T	2.495	2.505		2.500	2.500	2.500	2.500	"	"
U	1.357	1.367		1.362	1.362	1.367	1.362	"	"
V	0.787	0.807		0.797	0.797	0.797	0.797	"	"
W	0.540	0.560		0.550	0.550	0.550	0.550	"	"
X	1.674	1.684		1.679	1.679	1.679	1.679	"	"
Y	0.257	0.262		0.259	0.259	0.259	0.259	"	"
Z	0.912	0.932		0.922	0.922	0.922	0.922	"	"
AA	0.490	0.510		0.501	0.501	0.501	0.500	"	"
AB	0.178	0.198		0.188	0.188	0.188	0.188	Rig	RF
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: H.A.	Audited by: R
Date: 11/09/20	Date: 11.9.20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1	
Inspection Dwg: D2662 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.100	0.140		0.114	0.114	0.115	0.114	MJC	GA-03
B	0.100	0.140		0.136	0.124	0.124	0.124	MJC	118-120
C	1.125	1.145		1.1387	1.1352	1.136	1.157	Dial	HAAS2
D	0.615	0.685		0.683	0.683	0.683	0.683	Vern	GA-01
E	0.240	0.260		0.249	0.249	0.249	0.249	"	"
F	1.313	1.343		1.325	1.324	1.323	1.323	H-6	31006
G	0.210	0.230		0.220	0.220	0.219	0.219	Vern	GA-01
H	0.100	0.180		0.135	0.135	0.135	0.135	"	"
I	2.470	2.510		2.490	2.490	2.490	2.490	"	"
J	1.565	1.585		1.5787	1.5756	1.5765	1.577	Dial	HAAS2
K	0.235	0.240		0.238	0.238	0.238	0.238	Vern	GA-01
L	0.100	0.120		0.110	0.110	0.110	0.110	"	"
M	0.990	1.010		0.992	0.992	0.992	0.992	"	"
N	0.510	0.515		0.514	0.514	0.514	0.514	"	"
O	5.990	6.010		6.000	6.000	6.000	6.000	"	"
P	1.245	1.255		1.250	1.250	1.250	1.250	"	"
Q	2.495	2.505		2.500	2.500	2.500	2.500	"	"
R	0.313	0.318		0.315	0.315	0.315	0.315	"	"
S	0.315	0.322		0.317	0.317	0.317	0.317	"	"
T	2.495	2.505		2.500	2.500	2.500	2.500	"	"
U	1.357	1.367		1.362	1.362	1.362	1.362	"	"
V	0.787	0.807		0.797	0.797	0.797	0.797	"	"
W	0.540	0.560		0.550	0.550	0.550	0.550	"	"
X	1.674	1.684		1.679	1.679	1.679	1.679	"	"
Y	0.257	0.262		0.259	0.259	0.259	0.259	"	"
Z	0.912	0.932		0.922	0.922	0.922	0.922	"	"
AA	0.490	0.510		0.499	0.501	0.501	0.501	"	"
AB	0.178	0.198		0.188	0.188	0.188	0.188	R+6	ref.
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	B.A.
Date:	11/09/21

Audited by:	RP
Date:	11-9-26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN A	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED A	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE INSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

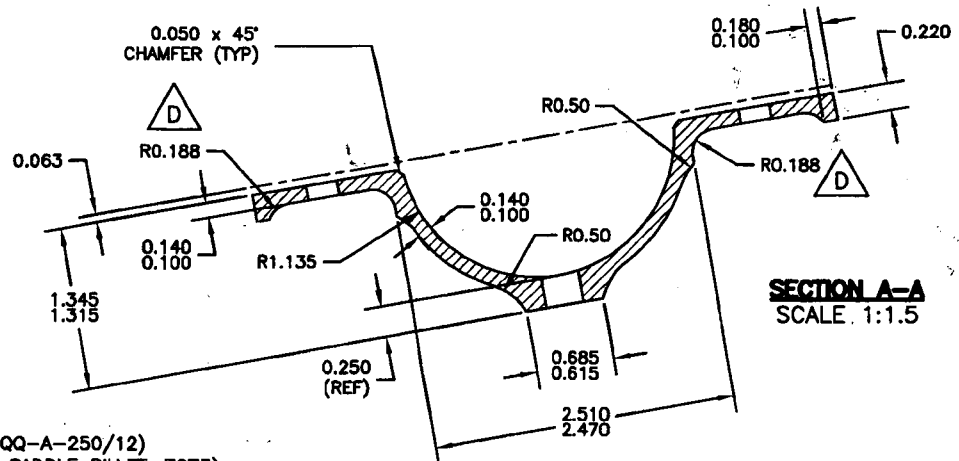
RELEASED

07.02.12

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WITHOUT NOTICE
WORK ORDER

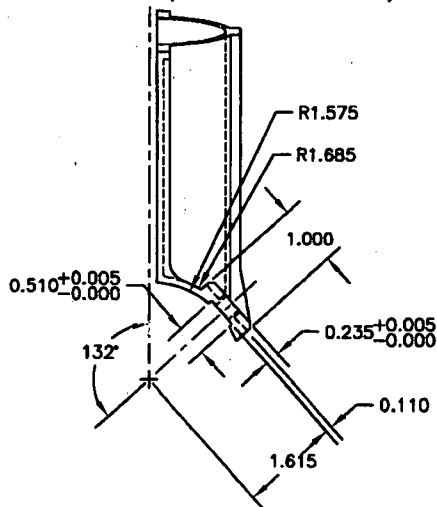
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PS10-12-8

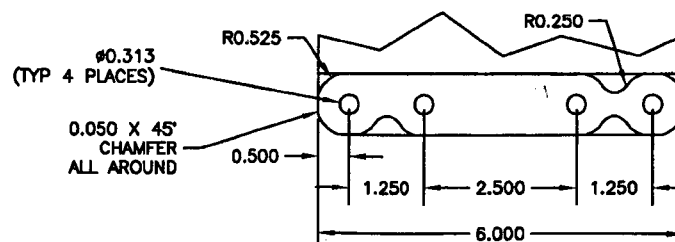
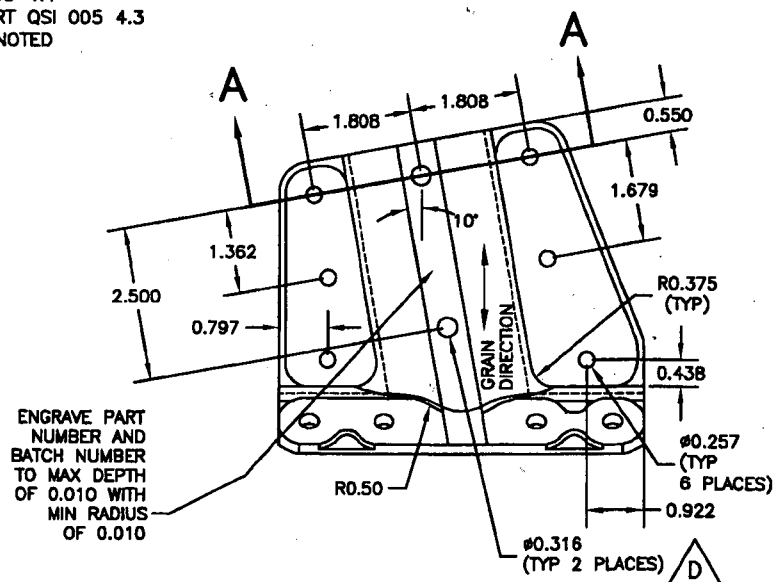
SECTION A-A
SCALE 1:1.5

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)



D2662-1 SADDLE INSIDE



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries